

Date: Monday, 08/06/2009 9:25:56 AM
User: Julie Dawson

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	BASKET BASE ASSEMBLY (350)		
Job Number	48393A				
Estimate Number	10189				
P.O. Number	:	Part Number	D2221		
This Issue	08/06/2009	S.O. No.	D2221 REV H		
Prsht Rev.	NC	Project Number	N/A		
First Issue	/ /	Drawing Revision	H		
Previous Run	48300C	Material	:		
Written By	:	Due Date	15/06/2009		
Checked & Approved By	<u>TD 09.06.08</u>	Qty:	1	Um:	Each
Comment	Est Rev:J 05.09.02 Added D3442-1 KJ/JLM Est Rev:K 08-08-29 revG as per dwg DD verified by:EC Est Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC Est Rev:M 08-12-02 revH as per dwg DD verified by:				
Additional Product					
Job Number:					
Seq. #:	Machine Or Operation:	Description :			
1.0	D22211	Rib			
					
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: <u>B 48318 → 1x</u> <u>SD 09/06/16</u>					
2.0	D22215	Rib			
					
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Rib batch: <u>B 46768 → 2x</u> <u>SD 09/06/16</u>					
3.0	D22217	Rib			
					
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: <u>B 46769 → 1x</u> <u>SD 09/06/16</u>					
4.0	D22323	Basket Hinge			
					
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Basket Hinge batch: <u>B 46949 → 2x</u> <u>SD 09/06/16</u>					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 08/06/2009 9:25:56 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 48393A

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

✓ 5.0 D22351 Basket Rib



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Rib

batch: B48451 → 2x

SM 09/06/16

✓ 6.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

batch: B47264 → 2x

SM 09/06/16

✓ 7.0 D34421 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Shim

batch: B46809 → 2x

SM 09/06/16

✓ 8.0 D3825041 Rib Assembly (Basket End)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rib Assembly (Basket End)

batch: B47075 → 2x

SM 09/06/16

✓ 9.0 D3826041 Rib / Gusset Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rib / Gusset Assembly

batch: B48431 → 2x

SM 09/06/16

✓ 10.0 D3827041 Rib Assembly (Inboard)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib Assembly (Inboard)

batch: B46090 → 1x

SM 09/06/17

✓ 11.0 D38331 Mesh (Base End Face)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mesh (Base End Face)

batch: B48217

SM 09/06/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries .

Date: Monday, 08/06/2009 9:25:56 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 48393A

Part Number: D2221

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	D38321	Mesh (Base)
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mesh (Base)

batch: B47266 → 1x

8/09/06/17

13.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221

2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221

3- tack weld mesh on basket as per dwg D2221

A/R ER316 S.S. Rod Batch: M109213

8/09/06/18

14.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

8/09-06-18

15.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

8/09/06/18 (X)

16.0	POWDER COATING	POWDER COATING
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M111472

Comment: POWDER COATING

Pressure wash 09-06-18

(1)

1- Plug holes prior to powder coating

2- Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME: 7:20 AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 7:50 AM

***** 2nd coat if necessary *****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8/09-06-18 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 08/06/2009 9:25:56 AM
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Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 48393A

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

17.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

So 06/13 (R)

18.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/19 (D)

Job Completion



MF

09-06-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8	7	6	5	4	3	2	1
D							
C							
B							
A							

D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

REvised
08/11/18

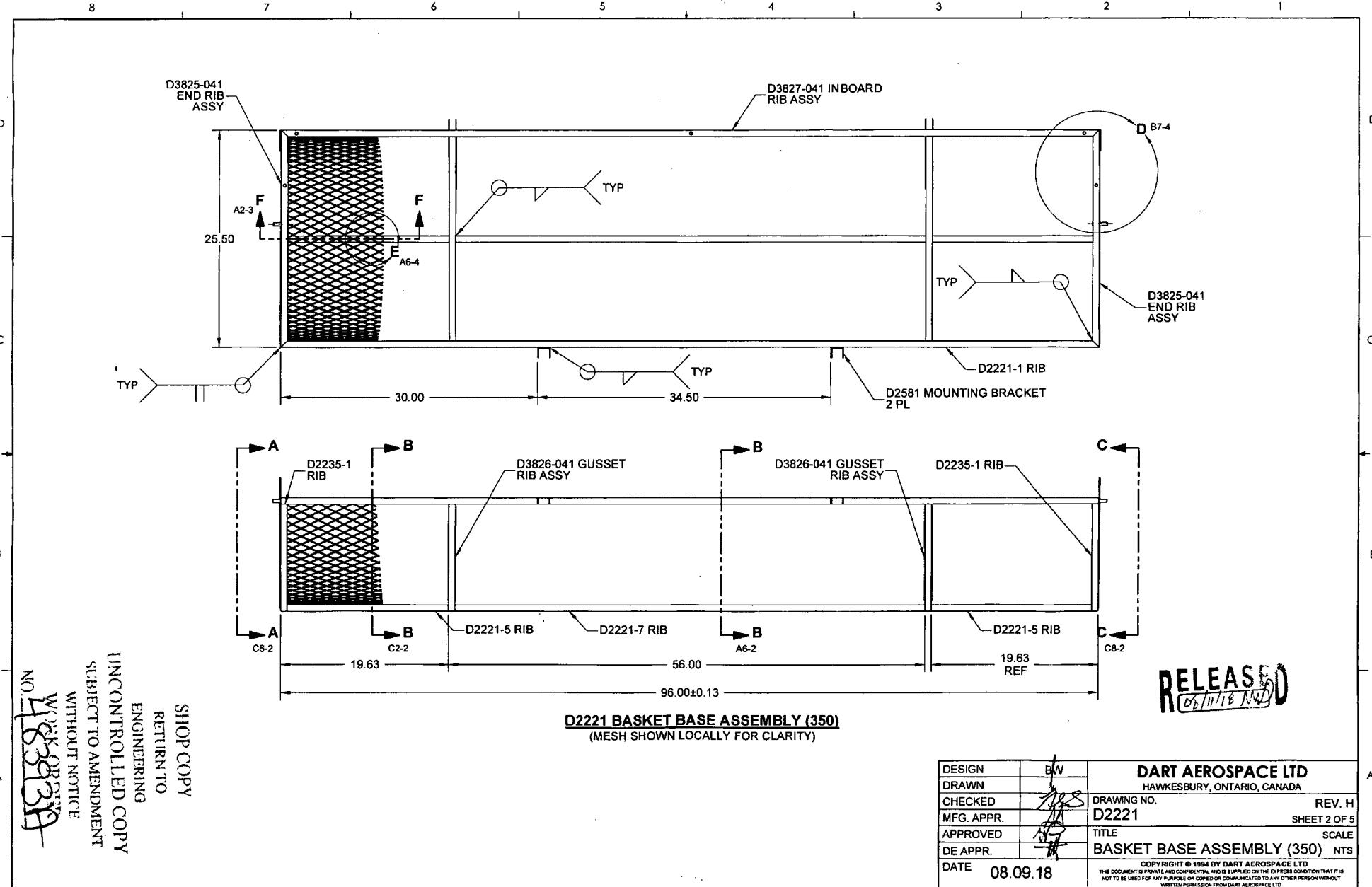
ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

H	REvised 08/11/18	B	
REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED SECTION E (ZN B8-1); REVISED SECTION F (ZN B9-1); ADDED DRAWING DETAILS FOR SHEET 1/5-7 (SHEET 5). TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3). D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.		MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR .96.00 DIM WAS +.00-.01 AND .56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BY		
CHECKED	MS	DRAWING NO. D2221	
MFG. APPR.	MS	REV. H SHEET 1 OF 5	
APPROVED	MS	TITLE BASKET BASE ASSEMBLY (350) NTS	
DE APPR.	MS		
DATE	08.09.18	SCALE COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

NO. **48393A**

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ENGINEERING

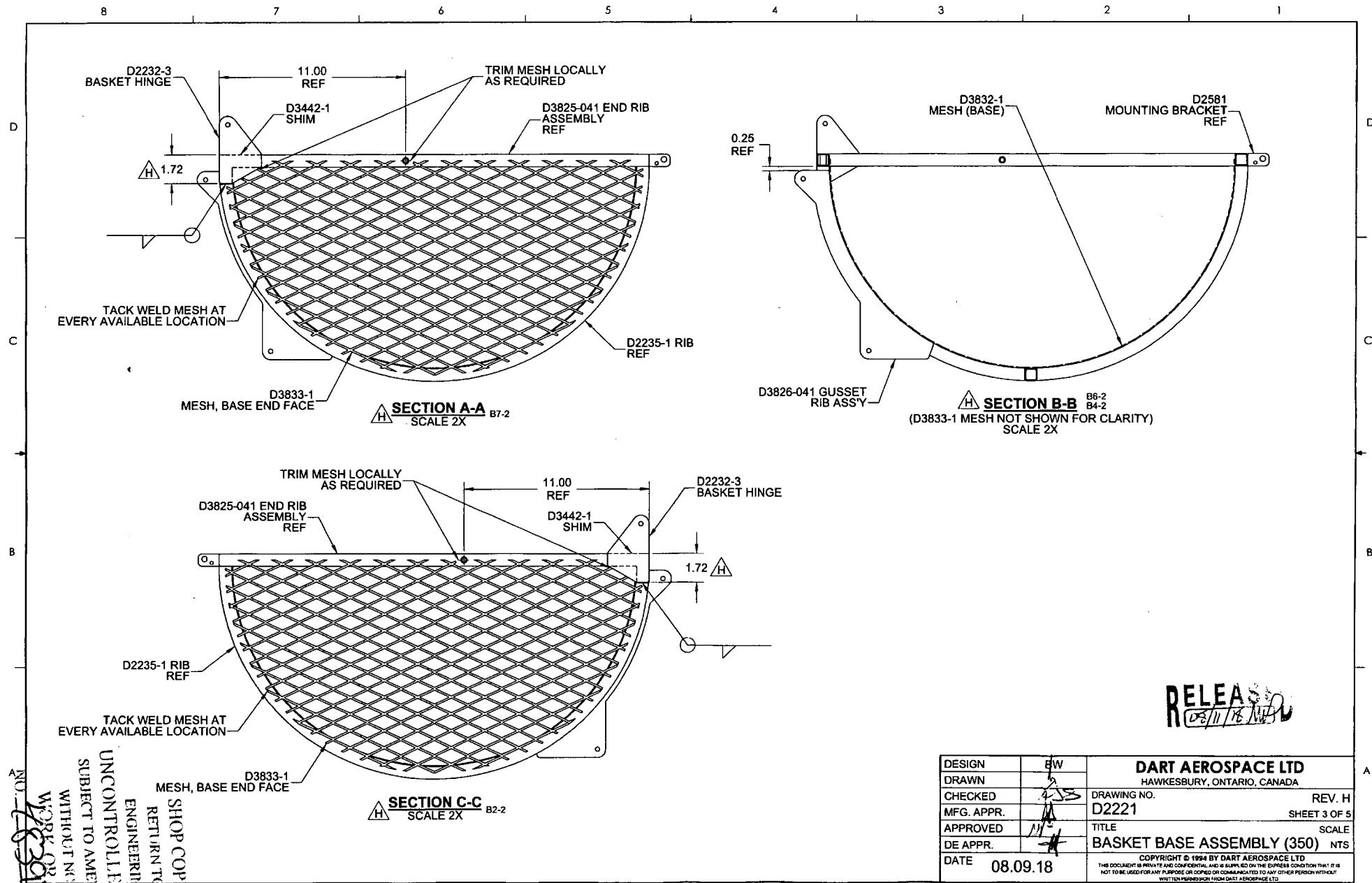
NOTES:
 1) MATERIAL: N/A
 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 42.00 lbs APPROX
 8) MASK ALL HOLES PRIOR TO POWDER COATING

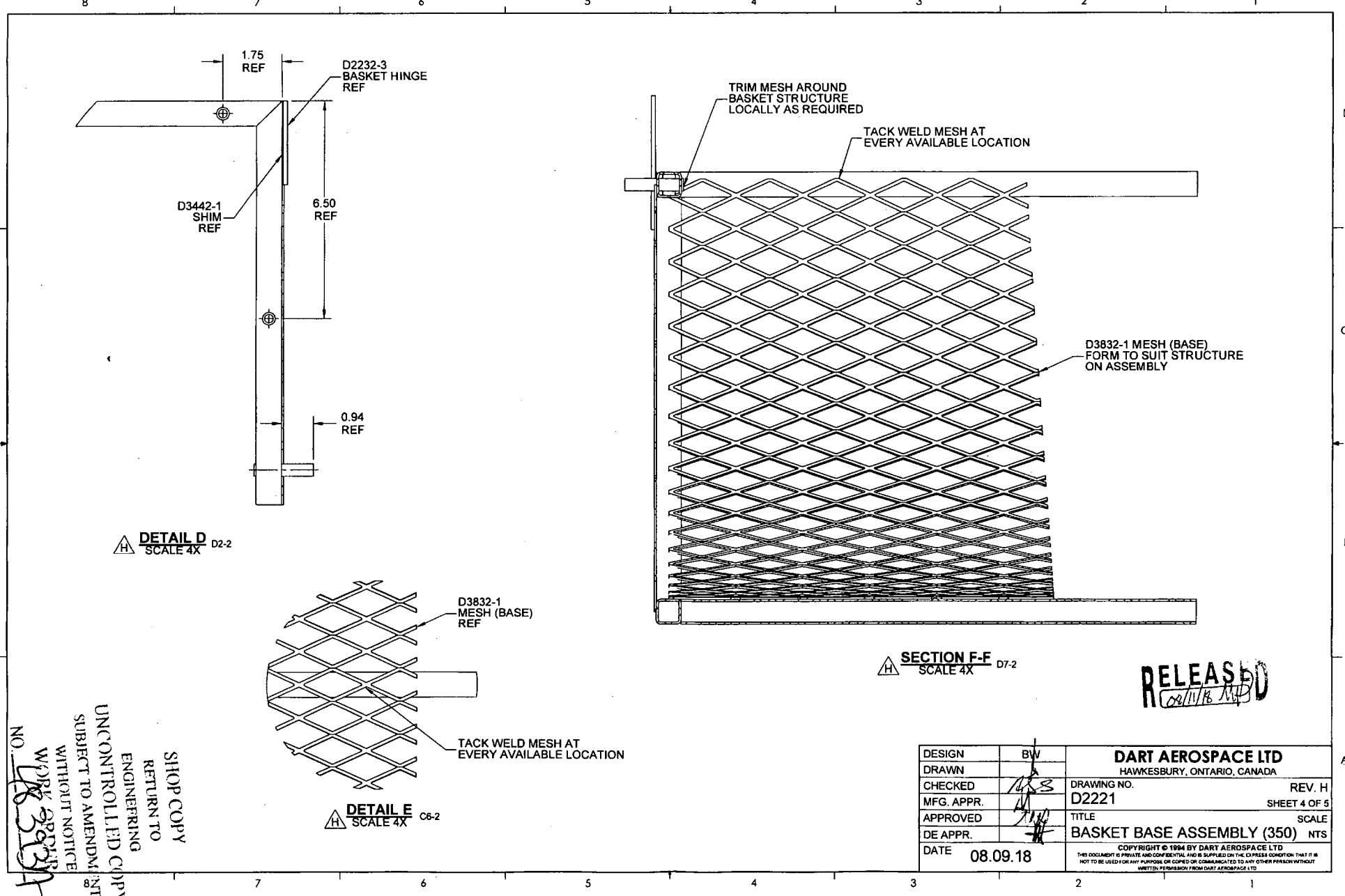


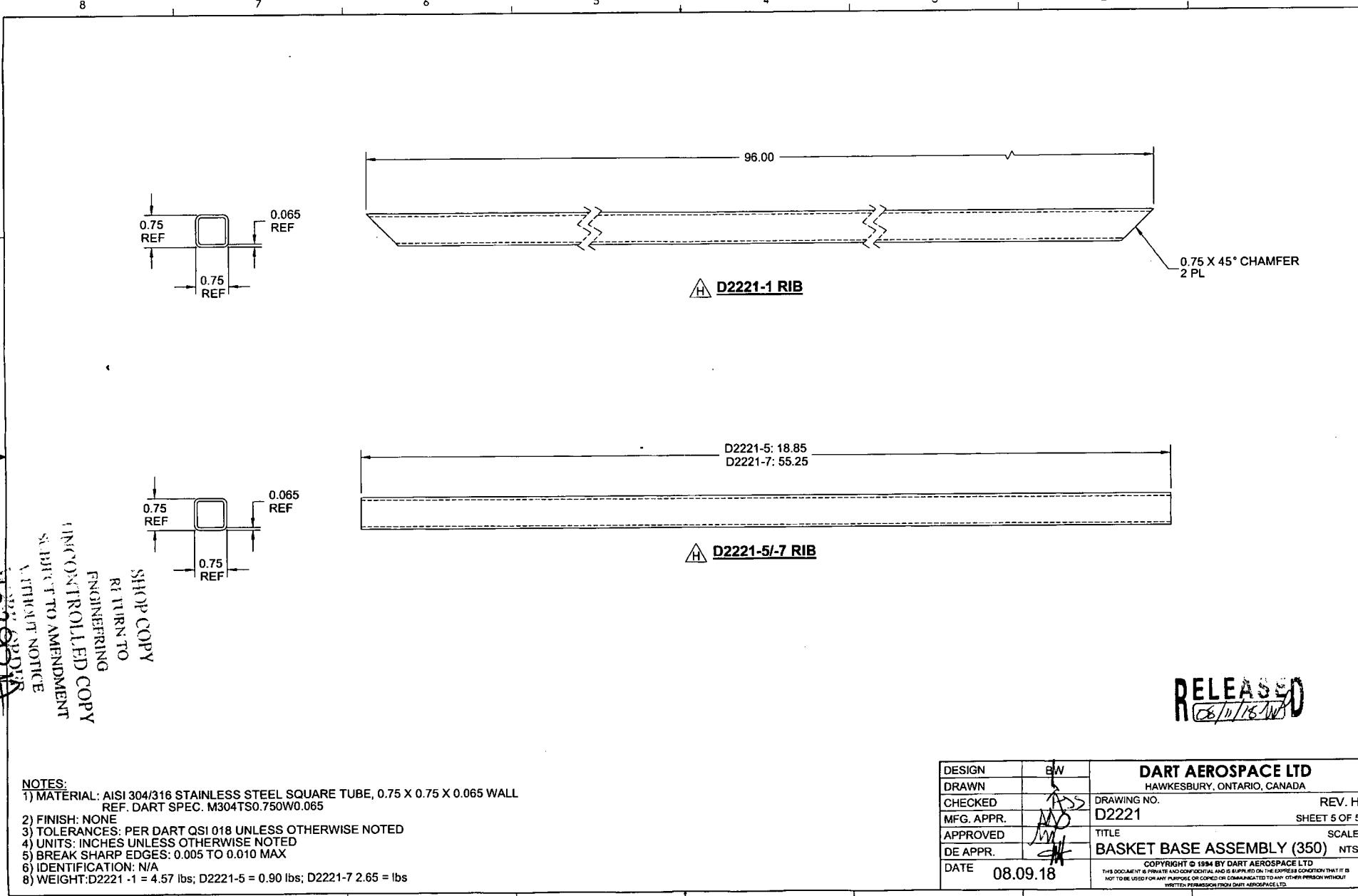
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D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED	<i>1/28</i>	DRAWING NO.	REV. H	
MFG. APPR.	<i>1/28</i>	D2221	SHEET 2 OF 5	
APPROVED	<i>1/28</i>	TITLE	SCALE	
DE APPR.	<i>1/28</i>	BASKET BASE ASSEMBLY (350) NTS		
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RELEASED
08/11/16 M